

DART SERVICE INSTRUCTION

TO AMEND MAINTENANCE MANUAL SUPPLEMENT MMS-D206-540

REF. CANADIAN STC: SH94-5

REF. FAA STC: SR00386NY

FOR D206-540-013 B3071 ONLY

The D2253 Lug Assembly and D2254 Gusset can be replaced as follows:

- (1) Clean area of paint, etc...
- (2) Remove existing D2253 Lug Assembly and D2254 Gusset as shown in Figure 1.

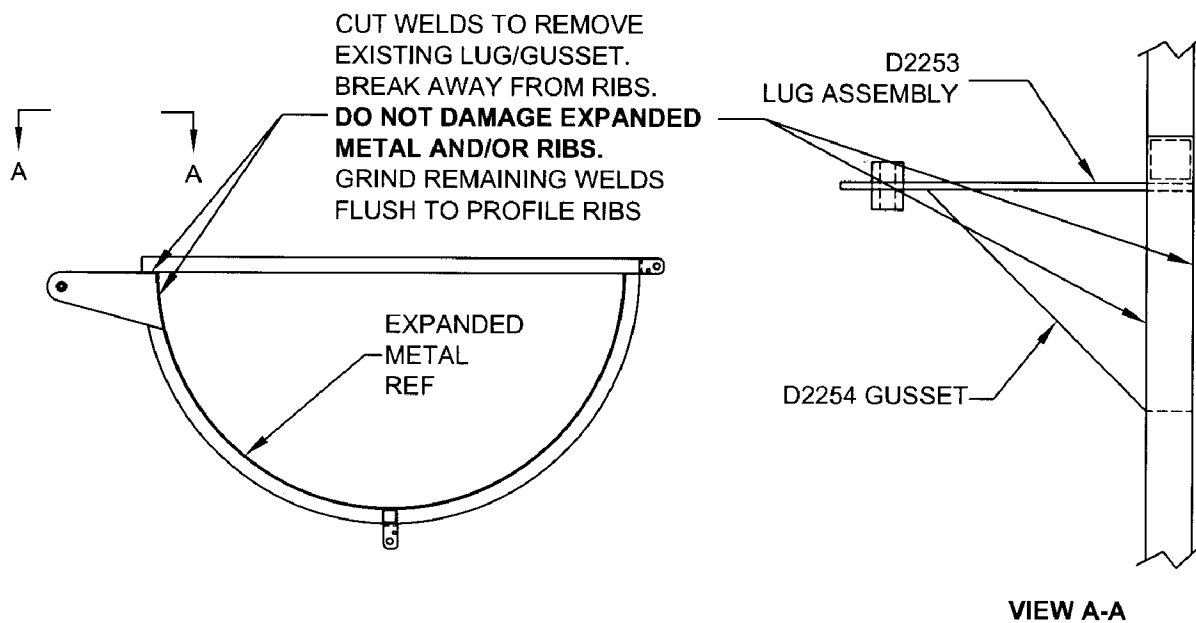


FIGURE 1 - REMOVAL OF EXISTING D2253 LUG ASSEMBLY AND D2254 GUSSET
(2 PLACES AS REQUIRED)

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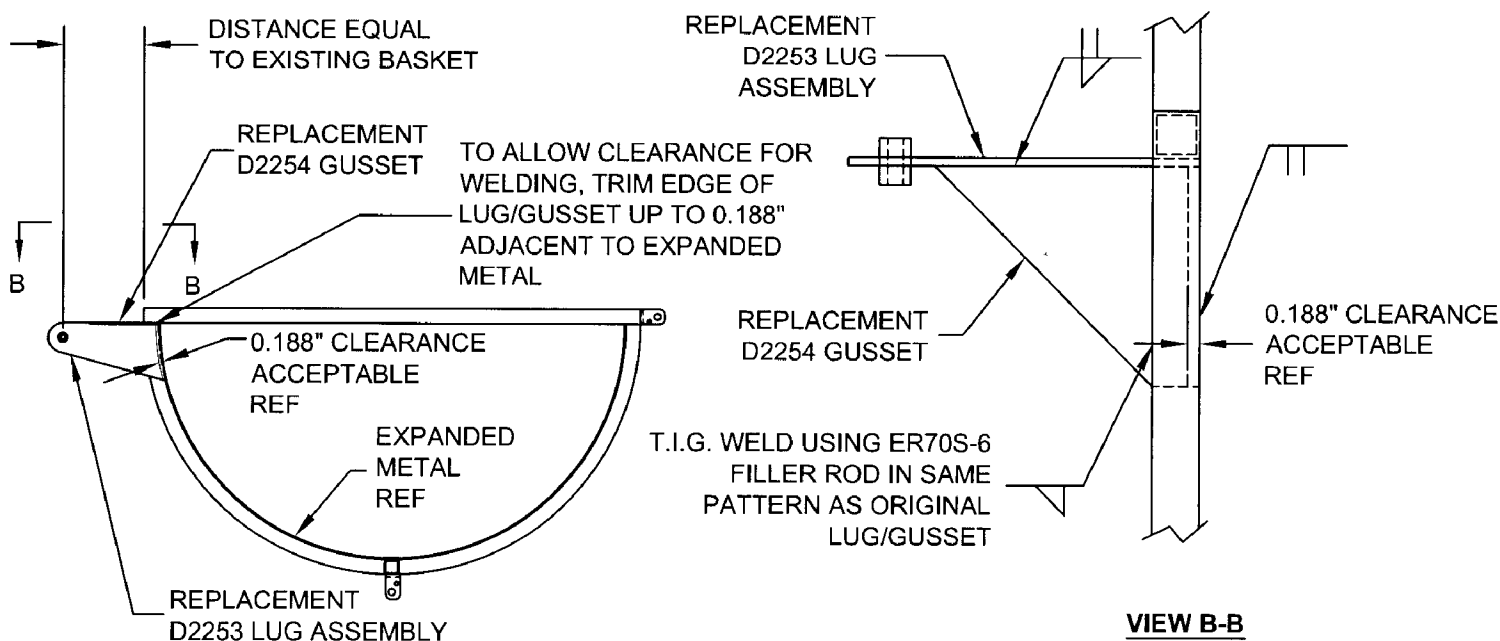
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BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 08.02.27
CERT. NO.: SH94-5
ISSUE NO.: 4

A	NEW ISSUE	PH	08.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PA</i>		
CHECKED	<i>LE</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9406	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE WELD REPAIR	NTS
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- (3) Install replacement D2253 Lug Assembly (Rev. A) and D2254 Gusset (made from AISI 1010-1025 steel) by welding per AMS-STD-2219 using ER70S-6 filler rod as shown in Figure 2 in same pattern as original lug assembly and gusset.
- (4) Touch up affected/repaired areas with one coat of MIL-P-85582 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.



**FIGURE 2 - INSTALLATION OF REPLACEMENT D2253 LUG ASSEMBLY
AND D2254 GUSSET
(2 PLACES AS REQUIRED)**

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DRAWN	PA		
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9406	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE WELD REPAIR	NTS
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